

Date: Tuesday, 12/20/2005 9:02:04 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BEARPAW KIT (13"X24")
Job Number	: 25291		
Estimate Number	: 11540		
P.O. Number	: N/A	Part Number	: K10006
This Issue	: 12/20/2005 S.O. No. : N/A	Drawing Number	: D2672 REV B1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B1
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 5/1/2006
Checked & Approved By	: SEE COMMENT BELOW	Qty:	10 Um: Each
Comment	: Est Rev: E 04.02.17 Tolerance added to Step 3 KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile:

K10006

D206-559-023

D350-578-021

and create labels per PPP K10006

CHG004(Bag Bluefiles separately)

DH 06/01/30

2.0

MUHMB10

UHMW 1" Black



Comment: Qty.: 2.3427 sf(s)/Unit Total: 23.4266 sf(s)

blank: 13.250" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2

Material: Black UHMW 1"

(MUHMB10)

Batch: M15926

M17227

SA 06.01.16

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2672 Identify as D2672

3-Deburr

JL/SA 06.01.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/20/2005 9:02:04 AM
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Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL/SA 06-01-16

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/01/16

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B050

Rubber Cushion



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2182B050 Rubber Cushion B23172

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2274 Radius Block B24872 71 MCP 29 MCP B25223

2 D2672(ref only) Bearpaw B25291

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick: Packing Kit


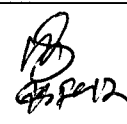
Qty Part Number Description Batch

6 D2438 Clamp B23818 43 MCP

B25015 X171

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 06/01/31
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-01-20	3	• 357 dims ^{Tapers} from from .357 → • .310 on one side only. Parts not perfectly centered/square.	 06-01-20	part acceptable. see also F.A.I. sheet.	SD 06-01-20	2 06-01-20	 06-01-20	2 06-01-20

NOTE: Date & initial all entries

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Part Number: K10006

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 D2529 Washer B25372

11.0

D2732050

Rubber Cushion



Comment: Qty.: 6.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion B24182

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M19085

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M15432

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 240.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M18431

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 120.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4

Nut (or -4)

M17997

Pack 1/24 (10)

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Log 01/30 10

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPK10006

Location:

REV 0

U 01/30 (10)

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SUE 06/01/31

(10)

DD 06/01/31 (10)

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	
Description: Bearpaw		Part Number:	D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1	

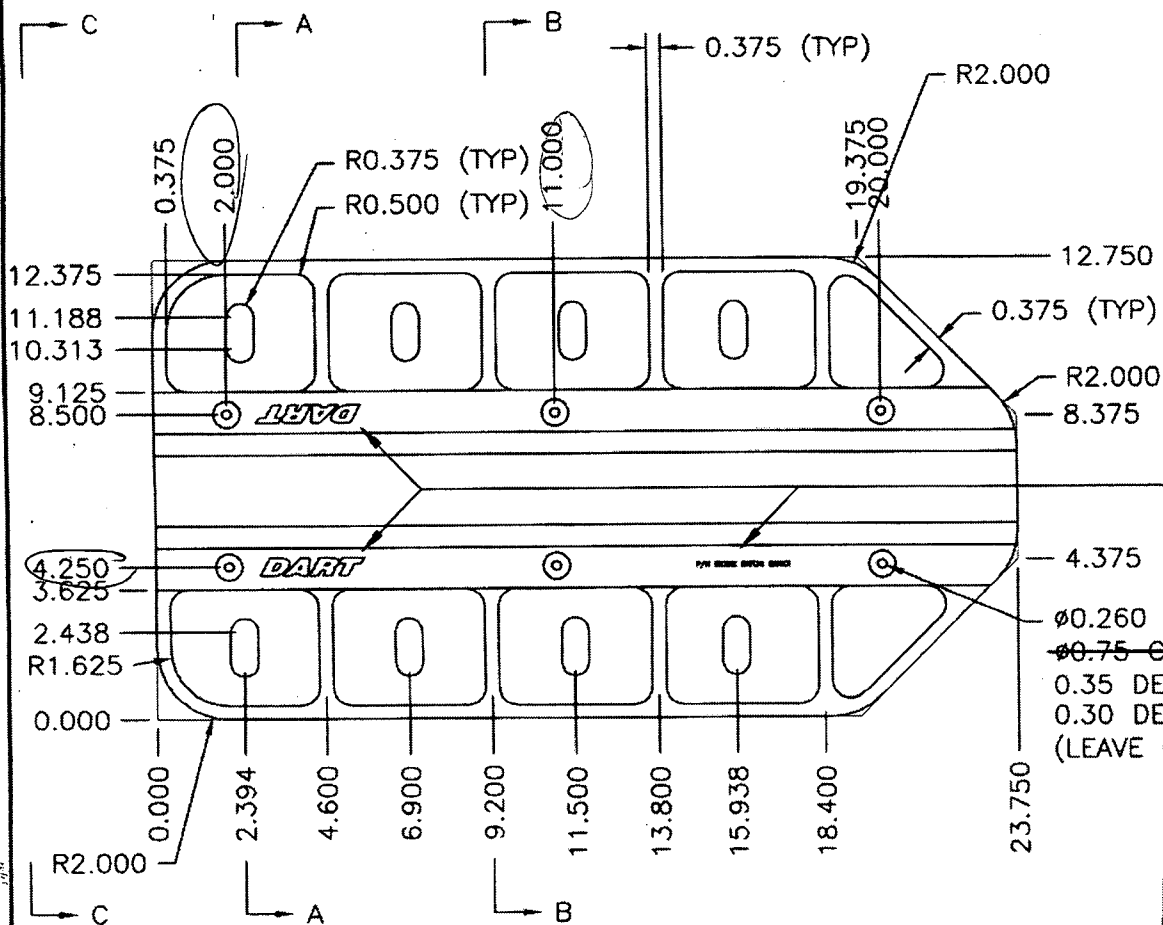
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	/		Tap	
B	12.750	+/-0.030	12.750	/		Tap	
C	4.250	+/-0.010	4.250	/			
D	2.000	+/-0.030	2.000	/			
E	9.000	+/-0.010	9.000	/			
F	0.375	+/-0.030	.375*	/		*TAPERS	DOWN TO
G	9.000	+/-0.010	9.000	/		0.310 AT AT	
H	Ø0.260	+0.005/-0.000	Ø.260	/		END OF BEARPAW.	
I	Ø0.93	+/-0.030	Ø.931	/			
J	0.300	+0.030/-0.000	.304	/		ACCEPTABLE DEVIATION	
K	0.625	+/-0.030	.635	/			06.01.19.
L	0.063 x 45°	+0.030/-0.010	.068 x 45°	/			
M	0.250	+/-0.010	.255	/			
N	5.500	+/-0.030	5.506	/			
O	R0.250	+/-0.030	R.250	/			
P	0.200	+/-0.030	.199	/			
Q	0.25 x 45°	+/-0.030	.250 x 45°	/			
R	0.950	+0.030/-0.010	.956	/			
S	0.375	+/-0.010	.381	/			

Measured by: SA	Audited by: SC	Prototype Approval:	N/A
Date: 06.01.16	Date: 06.01.16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	



ENGRAVE LOGO TO
MAX DEPTH OF
0.012. ENGRAVE
PART AND BATCH
NUMBERS TO MAX
DEPTH OF 0.010.
(TYPICAL LOCATION
AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C-BORE~~ Ø0.43 C-BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)

EFFECTIVE DEOS

RELEASED
93.06.17 KS

DESIGN	DRAWN BY	DART AEROSPACE LTD
LE	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
ME	KS	D2672
DATE	TITLE	REV. B
98.05.19	BEARPAW	SHEET 1 OF 2
A	NEW ISSUE	SCALE
B	CHANGE C-BORE, R1.58 WAS R1.50	1:5
B1	Ø0.43 WAS Ø0.75	

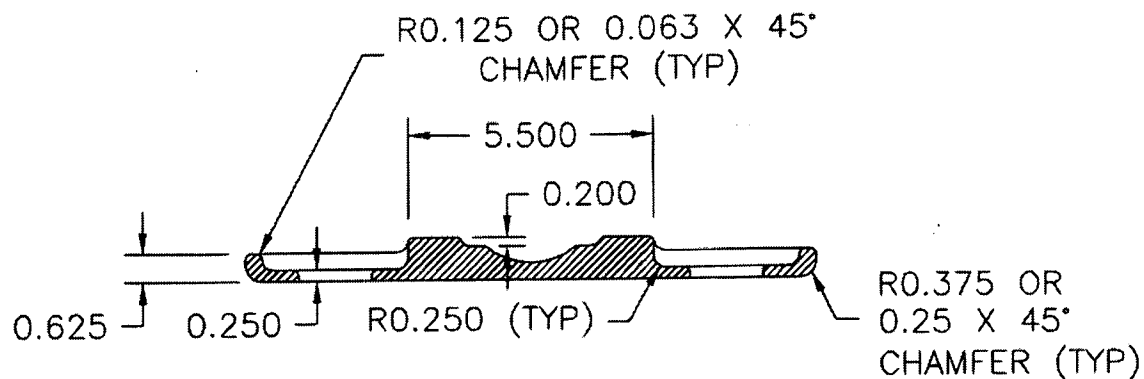
DART



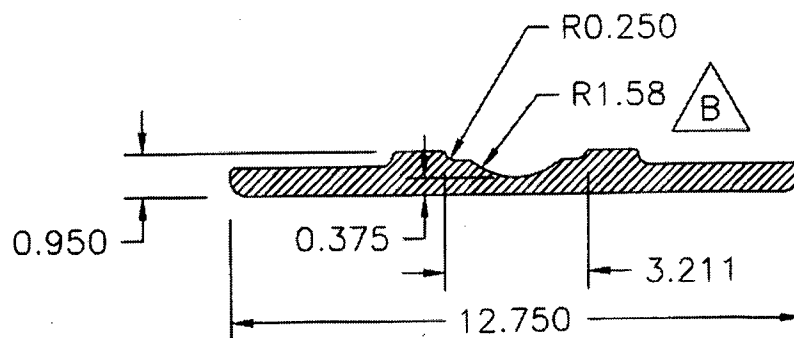


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED MAY	APPROVED [Signature]	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

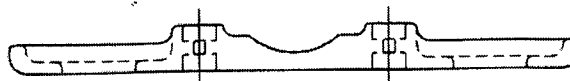
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99.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C